

FAI - 345

AI K/N

Work Order ID 69533

Wednesday, May 11, 2011 4:06:13 PM

Page 1

Item ID: D3492-5

Revision ID:

Item Name: Plug

Start Date: 5/11/2011 Start Qty: 40.00

Required Date: 5/16/2011 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:



Date: 11-05-12

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

Rev C

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

20 11-6-1

40 11-6-1

0.00

OK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69533

Page 2

Wednesday, May 11, 2011 4:06:13 PM

Item ID: D3492-5

Accept



Setup Start



Revision ID:

Item Name: Plug

Stop



Start Date: 5/11/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Operation
Description

Small Fab

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Small Fab

Small Fab

Memo

- 1-Deburr if necessary
- 2-Tumble

0.00



11/6/11

40 ✓

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

MAS

0.00

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

40 ✓ Mulaola 02

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69533

Wednesday, May 11, 2011 4:06:13 PM



Page 3

Item ID: D3492-5

Accept



Setup Start



Revision ID:

Item Name: Plug

Stop



Start Date: 5/11/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

170



QC

Quality Control

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo
(Flat End Only)
START TIME:
OVEN TEMPERATURE:
FINISH TIME:
4:00 01/11/14
320
4:30

40 X Ø M 11/06/14

QC3- Inspect Part Finish

0.00

40 d 11/06/15

Memo

0.00

180



Identify as per dwg & Stock Location:

F-P A
0.00

Packaging

Packaging

Memo

0.00

40 X Ø M 11/06/15

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69533

Wednesday, May 11, 2011 4:06:13 PM



Page 4

Item ID: D3492-5

Accept



Setup Start



Revision ID:

Item Name: Plug

Stop



Start Date: 5/11/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/06/15
11/06/15 (40)

11/06/15
11/06/15 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, May 11, 2011 4:06:19 PM

Work Order ID: 69533



Parent Item: D3492-5



Parent Item Name: Plug

Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.375 		Purchased	No			100	f	17.5000	0.06	2.526316 		SA 1116/1	

6061-T6 Round Bar .375"

Location	Loc Qty	Loc Code
MAT012	17.5	
112567	17.5	2.5 RX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69533
Description: Plug	Part Number:	D3492-5
Inspection Dwg: D3492	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: S.A.
Date: 11/6/11

Audited by:	RG
Date:	11-6-11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue P/O D3492-045	KJ/JLM	
B	06.10.16	Updated to Revision B	KJ/JLM	
C	07.10.30	Tolerance revised for Ø0.375	KJ/EC/DD	
D	08.11.28	Dwg Rev updated	KJ/EC	 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3492-XX PLUG
(SEE TABLE)NAS1611 PLUG
(SEE TABLE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64537

pl11-05/12

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D2492-3	PLUG
		€ 1	→				D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
							NAS1611-005	O-RING
							NAS1611-007	O-RING
1							NAS1611-010	O-RING
							NAS1611-012	O-RING
							NAS1611-013	O-RING
							NAS1611-015	O-RING
							NAS1611-016	O-RING

△ △ △

NOTES:

1) O-RING POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~

11.06.09
per NC2715B7/CASH-10
ONLY AFFECTS D3492-041/1

~~UNDER REVIEW~~

08.09.12
OK ASS 08.11.12

~~DEO ATTACHED~~~~RELEASED~~

C	ADD -049-051-953, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PL</i>	DART AEROSPACE LTD	
DRAWN	<i>PL</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PL</i>	DRAWING NO.	REV. C
MFG APPR.	<i>PL</i>	D3492	SHEET 1 OF 2
APPROVED	<i>PL</i>	TITLE	SCALE
DE APPR.	<i>PL</i>	PLUG	2:1
DATE	07.10.05	COPRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS REPLICATED OR COPIED EXCEPT WITH WRITTEN PERMISSION FROM DART AEROSPACE LTD NOT TO BE USED FOR ANY PURPOSE OR CONSIDERED AS RELATED TO ANY OTHER PERSON WITHOUT	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

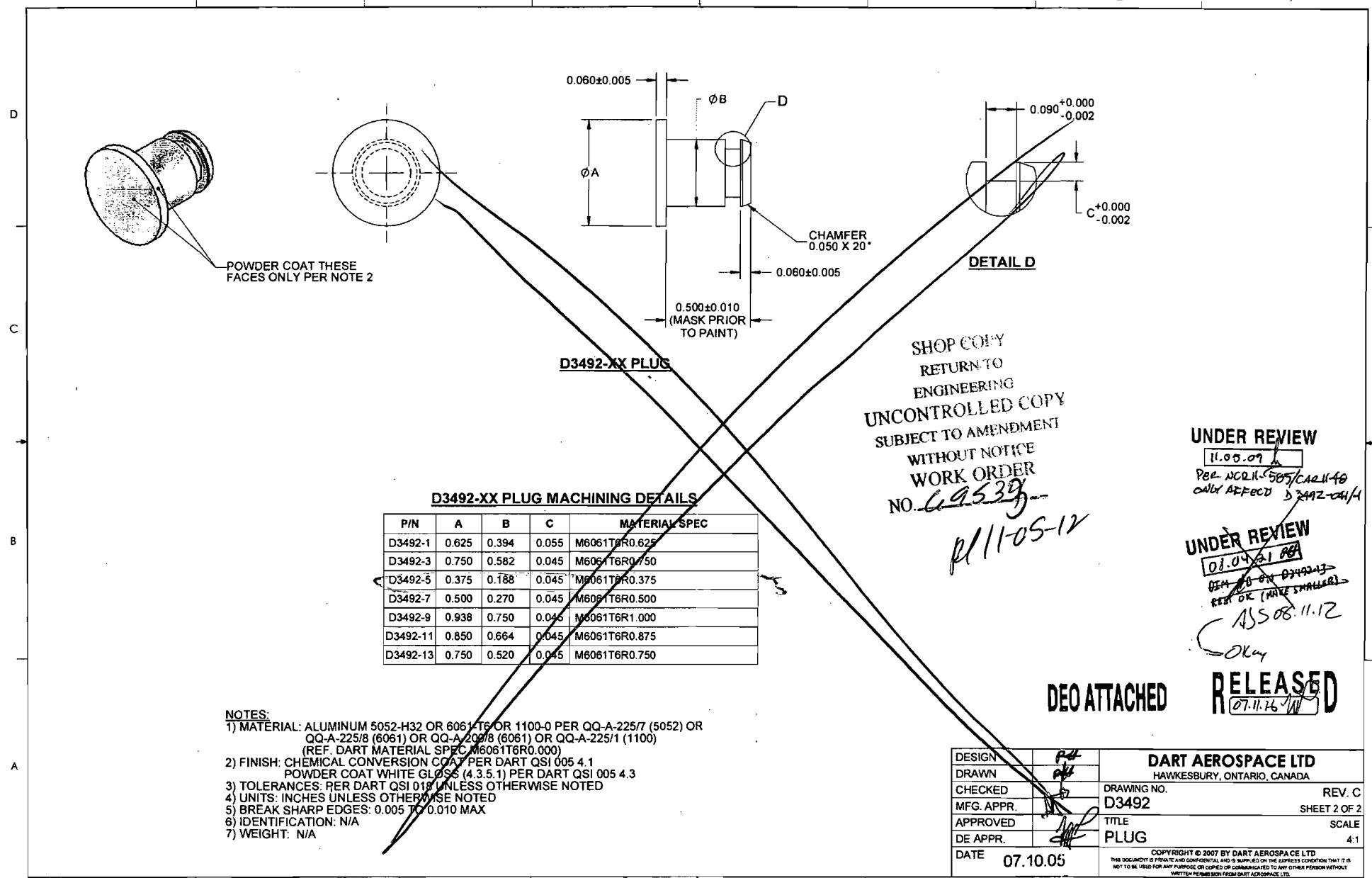
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W/O:		WORK ORDER CHANGES					
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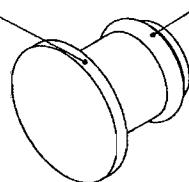
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3492-XX PLUG
(SEE TABLE) NAS1611 O-RING
(SEE TABLE)



D

D3492-XXX PLUG PARTS LIST

QTY .041	QTY .043	QTY .045	QTY .047	QTY .049	QTY .051	QTY .053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
							NAS1611-005	O-RING
							NAS1611-007	O-RING
1							NAS1611-010	O-RING
							NAS1611-012	O-RING
							NAS1611-013	O-RING
							NAS1611-015	O-RING
							NAS1611-016	O-RING

469533

RELEASED
2011-05-30
JF

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049-051-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JF	DRAWING NO.	REV. D
MFG. APPR.	JF	D3492	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

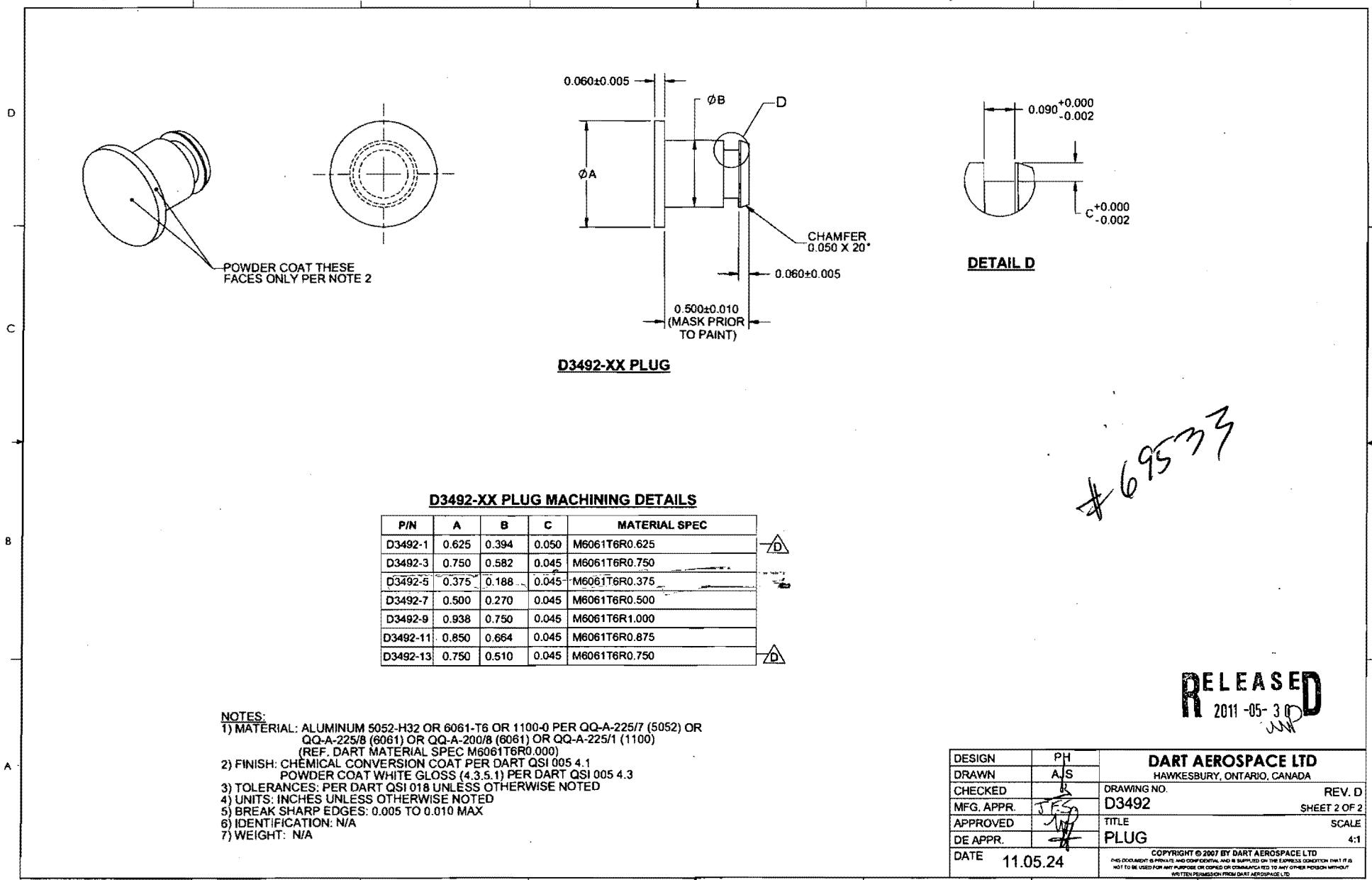
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